

Title (en)

METHOD FOR MANUFACTURING A QUENCHED AND TEMPERED SEAMLESS PIPE FOR A HIGH-STRENGTH HOLLOW SPRING

Title (de)

VERFAHREN ZUR HERSTELLUNG VON VERGÜTETEN NAHTLOSEN ROHREN FÜR EINE HOCHFESTE HOHLFEDER

Title (fr)

PROCÉDÉ DE FABRICATION D'UN TUBE SANS SOUDURE TREMPE ET REVENU POUR RESSORT CREUX HAUTE RÉSISTANCE

Publication

**EP 3214189 A1 20170906 (EN)**

Application

**EP 15855119 A 20151026**

Priority

- JP 2014222840 A 20141031
- JP 2015080126 W 20151026

Abstract (en)

To provide a method for manufacturing steel for a high-strength hollow spring that exhibits excellent resistance to hydrogen embrittlement. Disclosed is a method for manufacturing steel for a hollow spring obtained by quenching and tempering a seamless pipe for use as a material of the hollow spring, wherein the seamless pipe including predetermined components is subjected to a heat treatment is performed to satisfy quenching conditions (1) mentioned below, and to satisfy tempering conditions (2) mentioned below, (1) quenching conditions:  $26,000 \# T_1 + 273 \times \log t_1 + 20 \# 29,000$   $900^\circ\text{C} \# T_1 \# 1,050^\circ\text{C}$ , 10 seconds  $\# t_1 \# 1,800$  seconds, where  $T_1$  is a quenching temperature ( $^\circ\text{C}$ ), and  $t_1$  is a holding time (seconds) in a temperature range of  $900^\circ\text{C}$  or higher, and (2) tempering conditions:  $13,000 \# T_2 + 273 \times \log t_2 + 20 \# 15,500$   $T_2 \# 550^\circ\text{C}$ , and  $t_2 \# 3,600$  seconds, where  $T_2$  is a tempering temperature ( $^\circ\text{C}$ ), and  $t_2$  is a total time (seconds) from start of heating to completion of cooling.

IPC 8 full level

**C21D 9/02** (2006.01); **C21D 6/00** (2006.01); **C21D 9/08** (2006.01); **C22C 38/00** (2006.01); **C22C 38/02** (2006.01); **C22C 38/04** (2006.01); **C22C 38/06** (2006.01); **C22C 38/18** (2006.01); **C22C 38/20** (2006.01); **C22C 38/40** (2006.01); **C22C 38/42** (2006.01); **C22C 38/46** (2006.01); **C22C 38/48** (2006.01); **C22C 38/50** (2006.01)

CPC (source: EP KR US)

**C21D 6/005** (2013.01 - EP US); **C21D 6/008** (2013.01 - EP US); **C21D 9/02** (2013.01 - EP KR US); **C21D 9/08** (2013.01 - EP KR US); **C22C 38/00** (2013.01 - EP US); **C22C 38/001** (2013.01 - EP US); **C22C 38/02** (2013.01 - EP US); **C22C 38/04** (2013.01 - EP US); **C22C 38/06** (2013.01 - EP US); **C22C 38/18** (2013.01 - EP US); **C22C 38/20** (2013.01 - EP KR US); **C22C 38/24** (2013.01 - KR); **C22C 38/26** (2013.01 - KR); **C22C 38/28** (2013.01 - KR); **C22C 38/34** (2013.01 - KR); **C22C 38/40** (2013.01 - EP US); **C22C 38/42** (2013.01 - EP US); **C22C 38/46** (2013.01 - EP US); **C22C 38/48** (2013.01 - EP US); **C22C 38/50** (2013.01 - EP KR US)

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

Designated extension state (EPC)

BA ME

DOCDB simple family (publication)

**EP 3214189 A1 20170906**; **EP 3214189 A4 20180523**; **EP 3214189 B1 20190814**; CN 107148483 A 20170908; CN 107148483 B 20190301; HU E045800 T2 20200128; JP 2016089201 A 20160523; JP 6282571 B2 20180221; KR 20170063833 A 20170608; MX 2017005480 A 20170802; US 10526675 B2 20200107; US 2017306432 A1 20171026; WO 2016068082 A1 20160506

DOCDB simple family (application)

**EP 15855119 A 20151026**; CN 201580058015 A 20151026; HU E15855119 A 20151026; JP 2014222840 A 20141031; JP 2015080126 W 20151026; KR 20177011324 A 20151026; MX 2017005480 A 20151026; US 201515520616 A 20151026